

Date: Wednesday, 11/03/2009 2:39:08 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 46432 -1 Part Number : D2571
Estimate Number : 10530 Drawing Number : D2571 REV E
P.O. Number : Project Number : N/A
This Issue : 11/03/2009 S.O. No. : Drawing Revision : E
Prsht Rev. : NC Material :
First Issue : 11/03/2009 Type : MACHINED PARTS Due Date : 04/04/2009 Qty: 12 Um: Each
Previous Run : 45921
Written By :
Checked & Approved By : JUD09.03-11
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: B46412

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 46432 Double check by: mmf
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 46432

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/04/09 (4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09-04-9

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

m 110939

(5)

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

FL 09/04/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

09-04-09

KS

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

937

alyh

3x

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mr 09-04-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 410432
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.440			
B	1.745	1.755		1.750	1.747	1.747	1.749		
C	3.495	3.505		3.500	3.497	3.496	3.499		
D	1.745	1.755		1.750	1.748	1.747	1.748		
E	7.990	8.010		8.002	8.004	8.005	8.006		
F	0.490	0.510		.501	.506	.502	.503		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.376	.375	.377	.376		
I	0.490	0.510		.500	.504	.506	.504		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.568	.573	.571	.573		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.873		
P	0.115	0.135		.127	.124	.124	.127		
Q	0.115	0.135		.135	.135	.135	.134		
R	0.240	0.260		.252	.250	.250	.252		
S	0.115	0.135		.126	.128	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.959	2.958		
V	0.230	0.250		.242	.235	.236	.237		
W	0.115	0.135		.123	.125	.125	.125		
X	0.308	0.313		.310	.312	.312	.313		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.362	.364	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.632	.631	.630	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.244	.250	.250		
AE	1.375	1.395		1.391	1.395	1.394	1.393	1.387	
AF	0.115	0.135		.135	.126	.128	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.244	.242	.242		
AI	2.000	2.020		2.003	2.003	2.004	2.007	2.003	
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	09/04/05

Audited by:	RP
Date:	09/04/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46432
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				45	26	37	48		
A	0.438	0.443		.440					
B	1.745	1.755		1.746					
C	3.495	3.505		3.498					
D	1.745	1.755		1.746					
E	7.990	8.010		8.004					
F	0.490	0.510		.498					
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.378				
I	0.490	0.510		.504	.505				
J	1.174	1.184		1.177	1.178				
K	0.558	0.578		.574	.572				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.498	2.499				
O	3.869	3.879		3.872	3.871				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.125	.133				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.966				
V	0.230	0.250		.239	.237				
W	0.115	0.135		.126	.127				
X	0.308	0.313		.311					
Y	0.760	0.765		.760					
Z	0.352	0.372		.361					
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.635					
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250					
AE	1.375	1.395		1.387	1.389	1.394	1.391		
AF	0.115	0.135		.120					
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.244					
AI	2.000	2.020		2.003	2.005	2.009	2.002		
AJ	0.023	0.043		.023	.033				
Accept/Reject									

Measured by: mwe	09/04/88
Date:	

Audited by: SP	
Date: 09/04/89	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

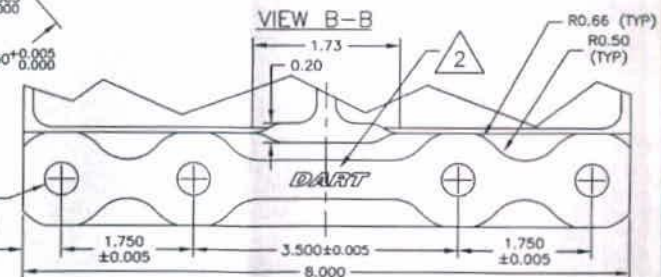
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E

VIEW B-B



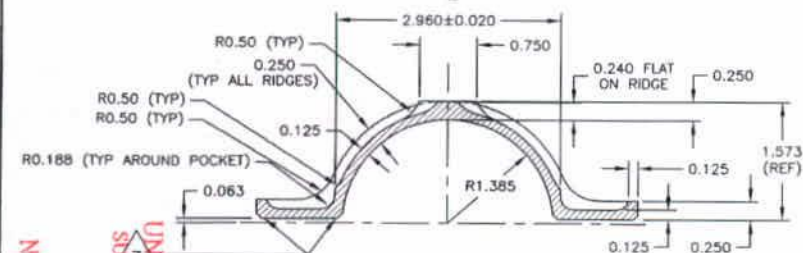
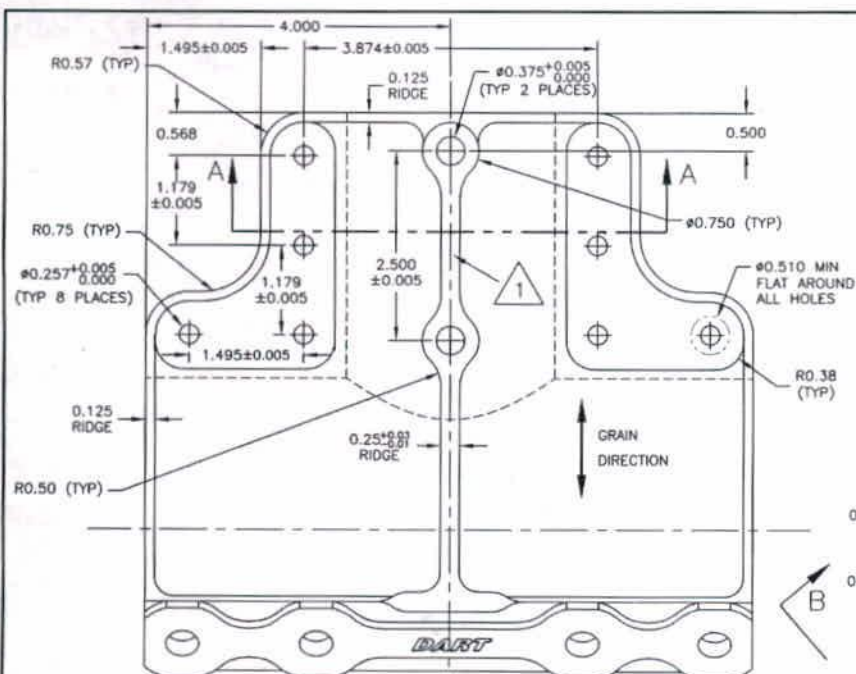
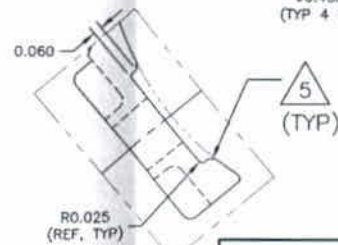
E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED	#	APPROVED	#	D2571	SHEET 1 OF 1
DATE	05.07.13	TITLE	OUTER FWD SADDLE		
				SCALE	2:3

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DETAIL C
 SCALE 4:3



SECTION A-A

NO WORK ORDER
 404352
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